Work Orde						*101	587*							Page	1
Item ID: Revision ID:	D3913-041				A	Accept	*N900	040	100	ን*	Setup	Start	*N	S1*	==
Item Name:	Long Basket l	Base Assemby	, 350									Stop	*N1	C2*	
Start Date:	5/13/2013	Start Qty:	1.00	**	1*		Cust Item 1	ID:					1.71	<b>.</b> 7/	
Required Date: Reference:	5/16/2013	Req'd Qty	1.00	**	1 *	`	Customer:								
Approvals:	Process Pla	an:	N	Date:/2-/	0-28	Tooling:	D:	ate:			Run	Start	*N	R1*	
	QC:			Date:		SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center ID		Operation Description	ı		4.1	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr	!			-									
D3913	С														
D4020	Α														
100	·	Weld per dwg	A/R S.S.	rod Batch: 1/2	23825	3 0.00						- ^ -			
*100*		Large Fab									١٧	OAS.	! 12	- 10	<b>っ</b>
Large Fab			lemo			0.00					<i>!</i>	9.6	15	-10-3	>
Large Fab		l· *	assemble **inspect l	ribs, weld as per before welding me	dwg D391 sh***	3 using DT9610A							V		
		2- ar	Cut D4020 nd trim mes	0-1 base mesh and sh to fit if necessar	tack weld ry and trim	all mesh on basket as p to clear fasteners holes	er dwg D3913 on the ends								
e e e e e e e e e e e e e e e e e e e				e (3) and Mountin o locate hinge and		as per dwg D3913									
		4-	Weld D46	572-1 blanking pla	tes as per o	lwg									
*110 *110*		QC9- Inspect	visual per (	QSI004- Fusion W	elds	0.00								DAS 9	
QC		M	lemo			0.00					13.	11-0	පි	9-89	

0.00

Memo

Quality Control

NCR: Y	'es / No				WORK ORDER NON-	COI	<b>NFORN</b>	//ANCE / UP!	DATE			
								-		QA Closed:	Date	e:
Work Orde	er:				DISPOSITION			·	AGAINST DE	PARTMENT	/PROCESS	
Part N	•				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ti	nitial	Ac <sup>1</sup>	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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,	Bending				Bend		Grain			Ovalized	L	Pressure/Forced
ļ	_	lot Conce	ntric to (	o/s	BOM/Route		Hardwa		L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	<u>_</u>	4	on Incomplete		Part Incorre	ct L	Weld
]		/Crimped			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	Vrong	
		on Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset					
	Torque \	Naves in E	Extrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Monday, Octobe				*101	1587*							Pa	age 2
Item ID: Revision ID: Item Name: Start Date:	D3913-041 Long Basket 5/13/2013	Base Assemby, 350	<b>+</b> 4 +	Accept	*N900	040	100	)*	Setup S	tart top	*N *N	S1 S2	
Required Date: 5 Reference: Approvals:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item   Customer:								
	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:				tart top	*N *N	R1 R2	*
Sequence ID/ Work Center II  120  *170* QC Quality Control	0	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Reject Qty	N	Reject Number	Insp. Stam DA: 9	р <b>S</b>

125

Pressure Wash per QSI005 4.3

0.00

\*125\* HandFinish Hand Finishing

Memo

0.00

1 26B.11-11

NCR:	• • • • • • • • • • • • • • • • • • • •													
<del>-</del> -						***					QA Closed:	Date:		
Work Orde	er:					DISPOSITION	_			AGAINST DE	PARTMENT		_	
Part N	•					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	CI	nief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	/Tooling ator crial cria						FAU	LT CATE	GORY	,				
Landi	ng G	Gear				General					<del></del>			
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		- ·	on Incomplete ions Incomplete/Unance led	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
1		Torque W	Vaves in E	extrusion	ո	Drawing	1	Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

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Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*101	587*							Page
Item ID: Revision ID:	D3913-041			Accept	*N900	040	100	<b>)</b> *	Setup		*N	S1*
Item Name: Lon Start Date: 5/12 Required Date: 5/16 Reference:  Approvals: Pr QC Sequence ID/	5/13/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				Stop	*N	S2*
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ite:			Run	Start	*N	R1*
(	QC:		Date:	_ SPC (Y/N):	Da	ite:				Stop	*N	R2*
Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rejo		Reject Number	Insp. Stamp
*130 *130* Powdercoat		White Gloss(Ref:4.3.5.2)	per QSI005 4.3-Steel	0.00				/	φ	13	-/1-/1.	DAS-
Powder Coating		1- Plug holes	and mask only interior of	of hinge (3) prior to powder								<b>34</b> 9-89
		######################################	PERATURE: 700 PE	 cessary**************	****							•

QC3- Inspect Part Finish

0.00

\*14**0**\*

Memo

0.00

Quality Control

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NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:													
									<u> </u>		QA Closed:	Date	2:	
Work Orde	er:					DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS		
Part I	۔ ِ No.					Rework Scrap Use-as-is Work Order Update		t Therm	Machining Sma	stube Ill Fab ishing posite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
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	Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs					Contamination		Mainte	nance		Part Moved		<u> </u>	
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other	
		Ripples in	Bend			Drill Holes		Offset			_	<b></b>		

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work	Order	ID -	101	587	
Monday,	October 2	8. 201	3 3:	48:34	РМ

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Page 4

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Item ID: Revision ID:	D3913-041			Accept	*N900	040	100	ገ*	Setup	Start	*N	S1*
Item Name: Start Date: Required Date: Reference:	5/13/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				Stop	*N:	S2*
Approvals:		an:		~ 6 _		ate:			Run	Start Stop	*N  *N	R1*
Sequence ID/ Work Center II  150  *150* HandFinish Hand Finishing  160.  *160* QC Quality Control		Operation Description Assemble as per dwg  Memo Pick Kit  QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty DAS	N	Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location: w/O	0.00 D <del>1000</del> 0.00 L D <u>1</u>	630-043/3	10158	015°	ر ا ا	\ <u>\</u>	_4 _	H	<u>wlulu</u>

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Work Ord	er:					DISPOSITION				AGAINST DE	PARTN	ΛENT,	/PROCESS		
Part NCR						Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Re		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
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Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Da	te	Verificatio	'n	QC Inspector
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Land	ing (	Gear				General									
		Bending				Bend		Grain			Ovaliz	ed			Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/I	Under	tolerance		Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part In				Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/	'Unclear	Part Lo	ost/Mi	ssing	П	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	-		Part M		-		
		Heat Trea	at			Countersink		Mislabe	led		Positio	ned V	Vrong		
		Inspectio	n Strin in	Tube		Cut Too Short		Misread		-	Power		J		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Ord Monday, Octob				*101	1587*							Page	5
Item ID: Revision ID: Item Name: Start Date: Required Date	5/13/2013	Base Assemby, 350  Start Qty: 1.00  Req'd Qty: 1.00	*1* *1*	Accept	*N900  Cust Item 1  Customer:		1100	)*	Setup	Start Stop	1 71	S1* S2*	
Reference: Approvals:	Process Pl		Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	I <i>Z</i> I	R1* R2*	
Sequence ID/ Work Center I  180 *180* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qt	ty	Reject Number	Insp. Stamp	- ろ

		-									DQA:	Date	e:
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	ANCE / UP	DATE			
			·						-		QA Closed:	Date	e:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	۔ . No				,	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	SORY				
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		7	on Incomplete ons Incomplete/i nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes		Offset			<del></del>	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPD	ATE	•		_	
											QA Closed:	Dat	e:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS		
Part I	No				¥	Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root Cause		Date	Step	Otv		tion of work order update or Non-conformance		Initial	Acti Descri	-	Sign &	Verification		OC Increases
Doc/Data	П	Date	Step	Qty		or Non-comormance		nief Eng	Descri	ption	Date	verification	+	QC Inspector
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Supplier	Ш	i.	•											
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Landi	_	1				General	_	7			1	-		
	Ш	Bending			.	Bend	<u>_</u>	Grain		<b>⊢</b>	Ovalized	}	_	Pressure/Forced
	Н	Centre N	ot Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa			Over/Under	<b>+</b>	-	Temperature/Cure
	Cracks <sup>‡</sup> Crushed/Crimped					Broken/Damaged	$\vdash$	1	on Incomplete	<u> </u>	Part Incorred	F	_	Weld
	$\vdash$		Crimped		<u> </u>	Burrs	<u> </u>	4	ions Incomplete/U	<u> </u>	Part Lost/Mi	ssing	\	Wrong Stock Pulled
	Cuffs					Contamination	$\vdash$	Mainte			Part Moved			
	Heat Treat Inspection Strip in Tube					Countersink	<u> </u>	Mislabe			Positioned V			
	$\vdash$	l '	•	Tube		Cut Too Short		Misread		L.	Power Loss/	Surge [	_[	Other
ļ	1	Ripples ir	1 Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Picklist Print Monday, October 28, 2013 3:48:	39 PM								Page 2
Work Order ID: 101587  Parent Item: D3913-041  Parent Item Name: Long Basket I	Base Assemby, 350		1587* 3913-041*				Start Date Start Qty:	: 5/13/2013	Required Date: 5/16/2013  Required Qty: 1.00
D3913-3 *D3913-3*	Manufactured	No		100	Each	1.0000	1 **	1 B100	2DAS
			Location WA004 100442	L	oc Qty	Loc Code	:		-
D3913-7 *D3913-7*	Manufactured	No	100 112	100	Each	8.0000	2 <b>**</b>	<sup>2</sup> B 948	338 <del>&gt;</del> 3x
			Location WA004 94828	<u>L</u> e	oc Oty 8 8	Loc Code		· .	328 →2x *0As 43, 13.10.28
73913-9 *D3913-9* Hinge Rib	Manufactured	No		100	Each	7.0000	i <b>**</b>	B/003	10AC 13.10.48
			<u>Location</u> WA004 100305	Lo	7 7	Loc Code			· · · · · · · · · · · · · · · · · · ·
D3916-041 D3916-041* Rib Assembly	Manufactured	No		100	Each	4.0000	2 **	2 B19286	8 -> 2x 10/03 13.10 :
			<u>Location</u> WA004 102868	<u>Lo</u>	0c Oty 4 4	Loc Code			- · · · · · · · · · · · · · · · · · · ·
103916-5 12D3916-5* Light Rib	Manufactured	No		100	Each	12.0000	3 <b>**</b>	3 B 107	318 > 3x 13 10
			<u>Location</u> WA004 107318	<u>Lo</u>	12 12	Loc Code			- -

Monday, October 28, 2013 3:48:40 PM

Shop Packet Print

Page 2

Operator Material Setup Other Frocess Supplier Training Unapproved  Bending Centre Not Concentric to O/S Contre Not Concentric to O/S BOM/Route Bom General  Bom General Counter Not Concentric to O/S Cracks Broken/Damaged Broken/Damaged Broken/Damaged Burrs Broken/Damaged Burrs Broken/Damaged Burrs Broken/Damaged Burrs Burrs Burrs Burrs Burrs Broken/Damaged Burrs Burrs Burrs Burrs Broken/Damaged Burrs Burr								•				DQ	A:D	ate:	;	
Work Order:    Part No.	NCR: Y	Yes	/ No				<b>WORK ORDER NON-C</b>	100	NFORM	<b>MANCE / UP</b>	DATE					
Part No.												QA Close	d: D	ate:		
Part No.	Work Orde	er:					DISPOSITION			<u> </u>	AGAINST DE	PARTMEN	IT/PROCESS			
Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification   QC Inspector	Part N	۔ ِ No.					Scrap Machining Use-as-is Thermoforming				Small Fab Finishing	nall Fab Prod. Eng. Coor. Qualinishing Rec/Store/Packaging Oth				
Doc/Data	Root	Ī				Descri	otion of work order update		Initial	Ac	tion	Sign &				
Equip/Tooling Operator	Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verificati	on	QC Inspector	
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Cuffs Countersink Countersink General Grain Grain Grain Grain Hardware Hardware Hardware Hardware Hardware Hardware Hardware Hardware Over/Under tolerance Temperature/Cure Weld Part Incorrect Weld Part Lost/Missing Wrong Stock Pulled Part Moved Part Moved Positioned Wrong	Equip/Tooling Operator Material Setup Other Process Supplier Training		ļ. <b>-</b>			-										
Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong			<del> </del>					AUL	LT CATE	GORY						
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I I INSPECTION STrip in Tupe I Tout Too Short I IMisread I I Power Loss/Surge I Tother		<b>├</b> ── <b>┤</b>						$\vdash$	→							
Ripples in Bend   Drill Holes   Offset		Inspection Strip in Tube						-	4	I	<u>L</u>	JPower Los	ss/Surge	<u></u>	Other	

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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End Mesh, Basket

			DQA:	Date:	:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N			-			Rework Scrap Use-as-is Work Order Update		l hern	Machining noforming	Crosstube Small Fab Finishing Composite	Pro Rec/Stor	€ngineering Quality Other	
Root					Descri	ption of work order update	Init	ial	Action	n	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	Eng	Descript	tion	Date	Verification	QC Inspector
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Operator													
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Setup													
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	<del>  </del>	ending			<u> </u>	Bend	$\boldsymbol{\vdash}$	rain			Ovalized	Ĺ	Pressure/Forced
			t Concer	ntric to (	D/S	BOM/Route	$\vdash$	ardwa			Over/Under	tolerance	Temperature/Cure
		acks				Broken/Damaged	$\vdash$	-	on Incomplete		Part Incorred	<b>⊢</b>	Weld
		Crushed/Crimped				Burrs	—		ions Incomplete/Unc	<del> </del>	Part Lost/Mi	ssing	Wrong Stock Pulled
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	Heat Treat				<u> </u>	Countersink	Шм	islabe	eled		Positioned V		<del>_</del>
	Inspection Strip in Tube					Cut Too Short	<b>—</b>	isread	i		Power Loss/	Surge	Other
					Drill Holes	Offset							
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Page 4

NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
					-			_			QA Closed:	Date	:
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	Part No.  NCR No.					Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other	
Root					Descri	otion of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descr	iption	Date	Verification	QC Inspector
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Out of Sequence

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Turning Sequence

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Picklist Print Monday, October 28, 2013 3:48:41	! PM									Page 6
Work Order ID: 101587		*1	N1587*							
Parent Item: D3913-041			3913-041*	•						•
Parent Item Name: Long Basket Ba	se Assemby, 350		3913-041	•		Sto	rt Date: 5	/12/2012	Description I.D. 4 - 5/1:	(10010
	<b>.</b>								Required Date: 5/10	
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Cherry Rivets	/V.5"						A A		DAS 28	·
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## **Picklist Print**

Monday, October 28, 2013 3:48:41 PM

Work Order ID: 101587

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

\*101587\* \*D3913-041\*

125646

**Start Date: 5/13/2013** 

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**Required Date: 5/16/2013** 

Page 7

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

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12

12

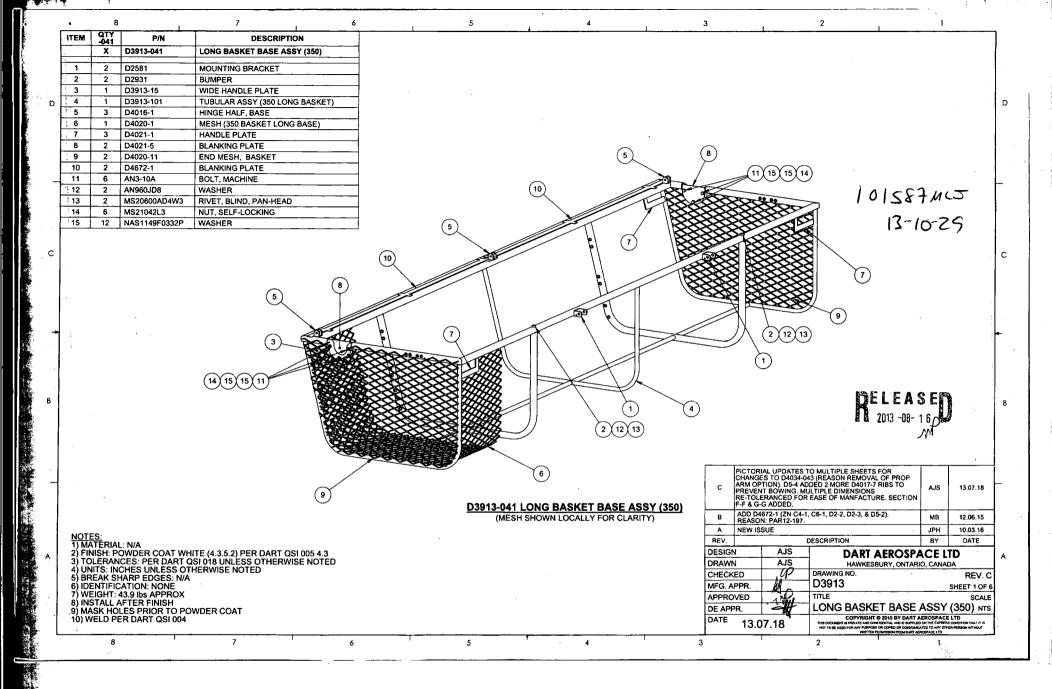
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Outside Dimensions

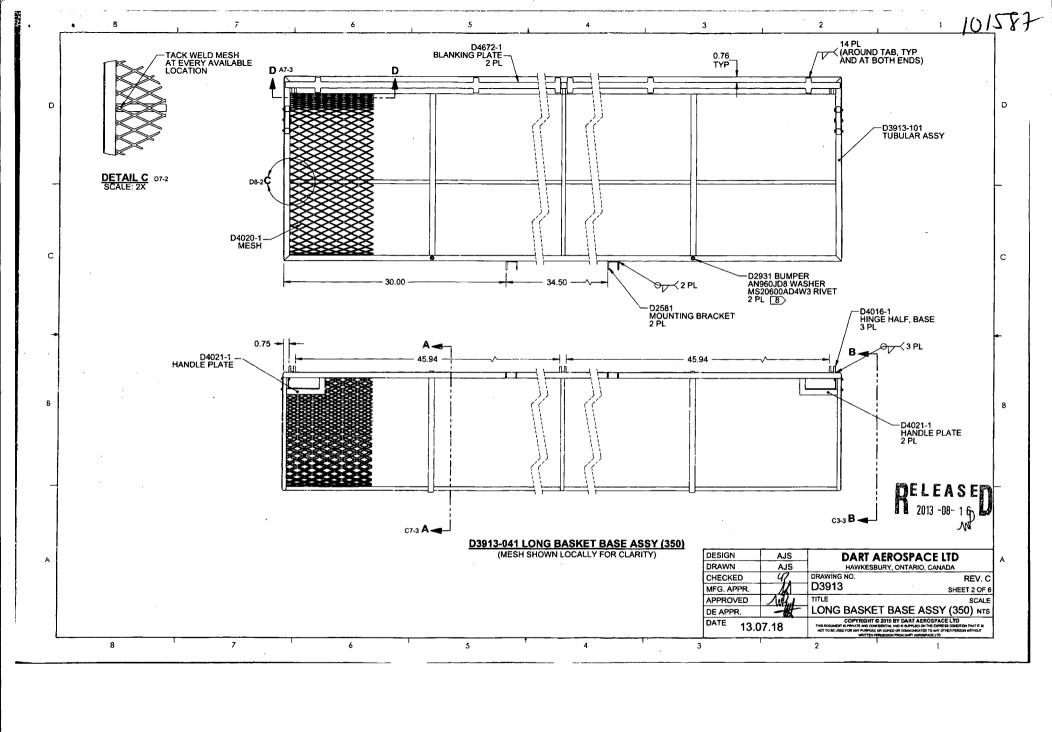
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Wave/Twist in Tube

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Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

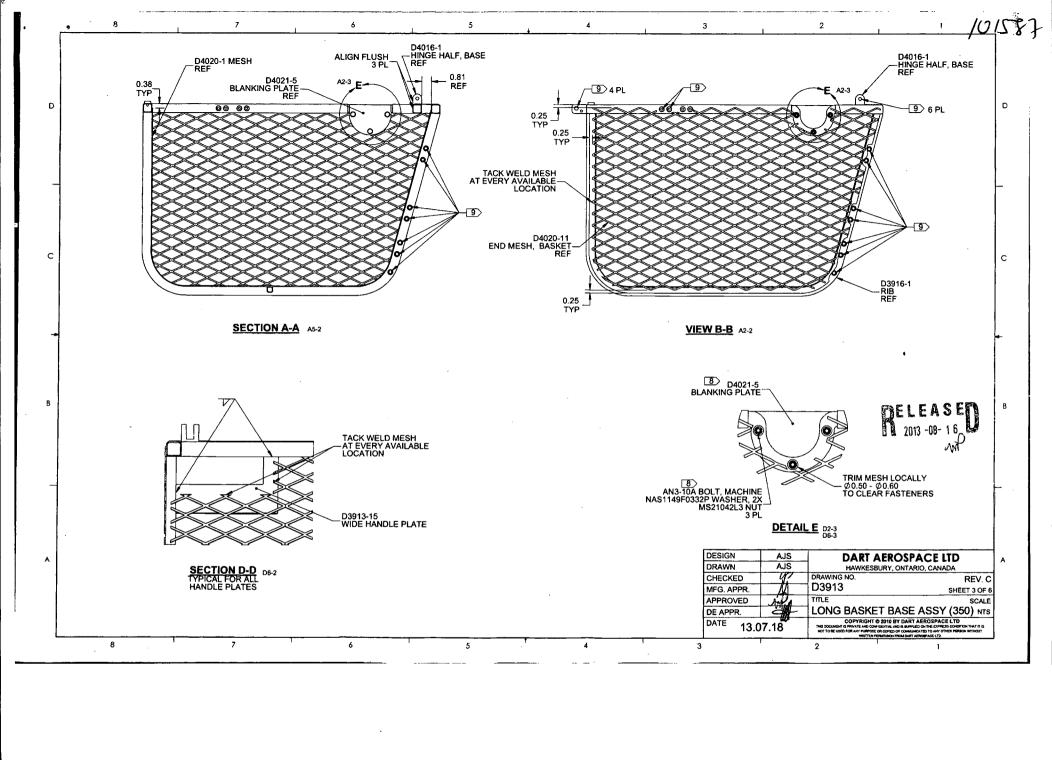
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Outside Dimensions

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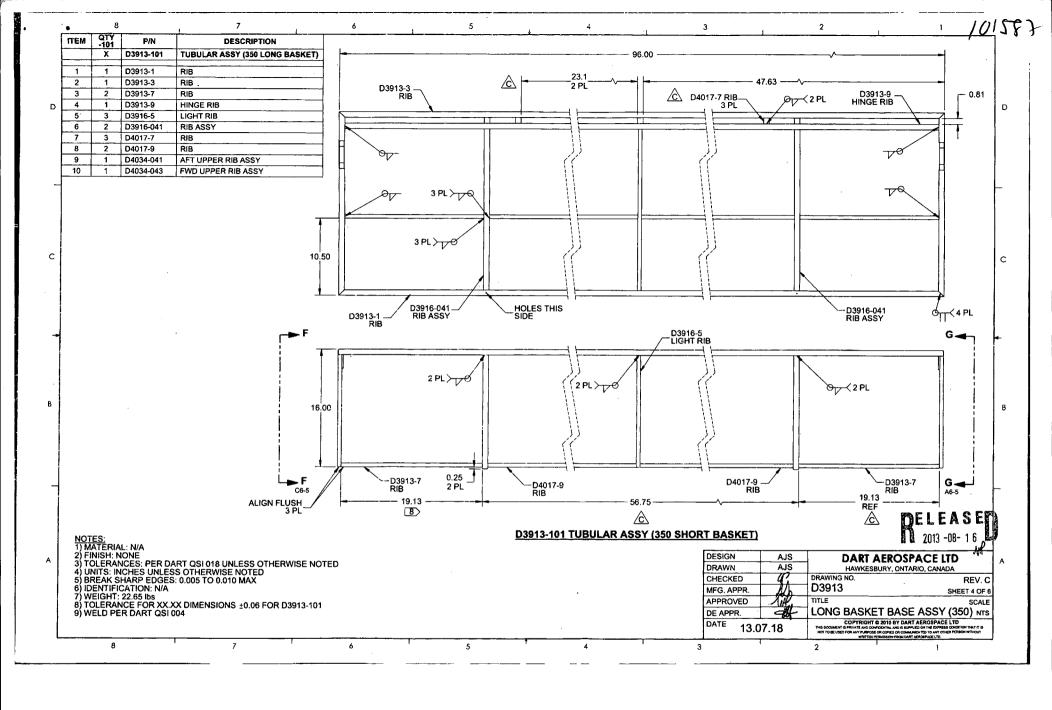
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Turning Sequence

Wave/Twist in Tube

Finish

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Cuffs					Contamination		Maintenance			Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Heat Treat

Countersink

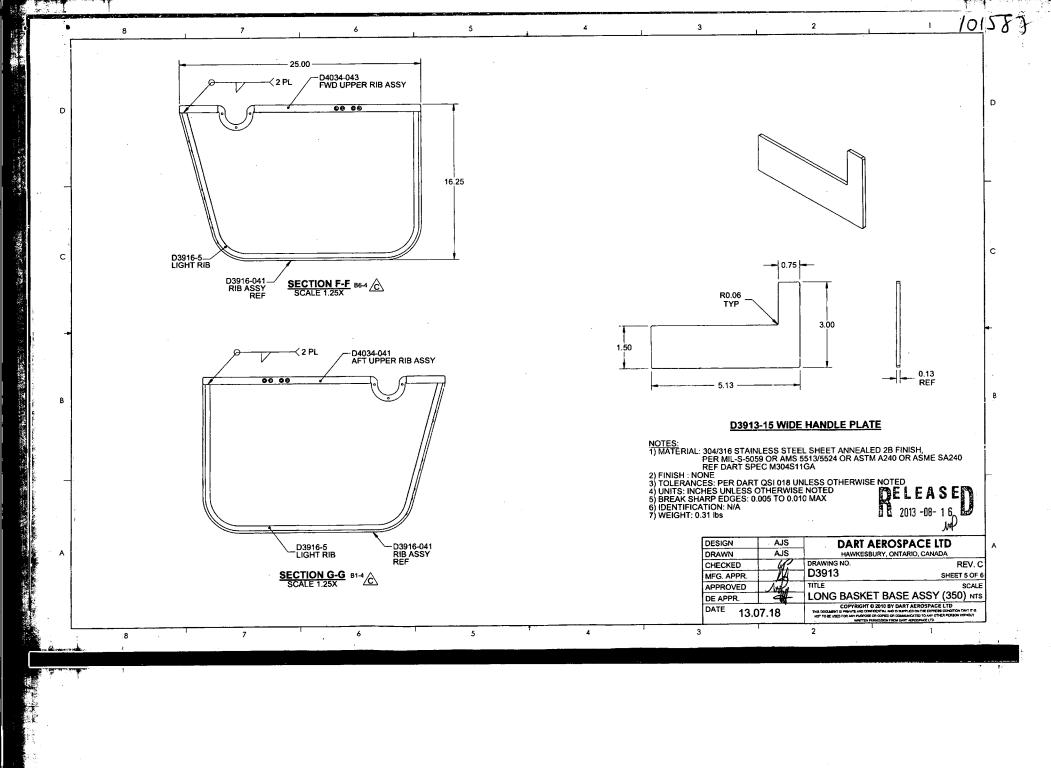
Cut Too Short

Drill Holes

Drawing

Finish

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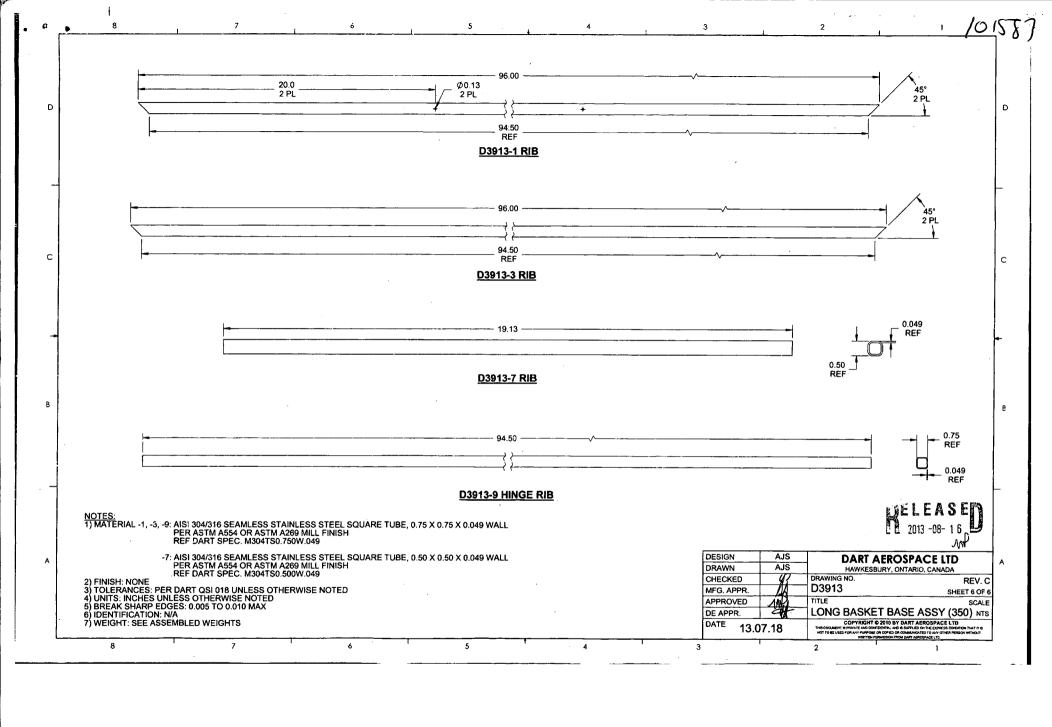
Outside Dimensions

DQA:

Date: \_\_\_

Wave/Twist in Tube

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DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Machining Small Fab Quality Part No. Prod. Eng. Coor. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. **Work Order Update** Large Fab Composite Supplier Description of work order update Action Sign & Root Initial Qty Chief Eng Verification or Non-conformance Cause Date Step Description Date QC Inspector Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Instructions Incomplete/Unclear Crushed/Crimped Wrong Stock Pulled Burrs Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong

Misread

**Out of Calibration** 

Out of Sequence

**Outside Dimensions** 

Offset

Power Loss/Surge

Other

**Turning Sequence** 

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

**Torque Waves in Extrusion** 

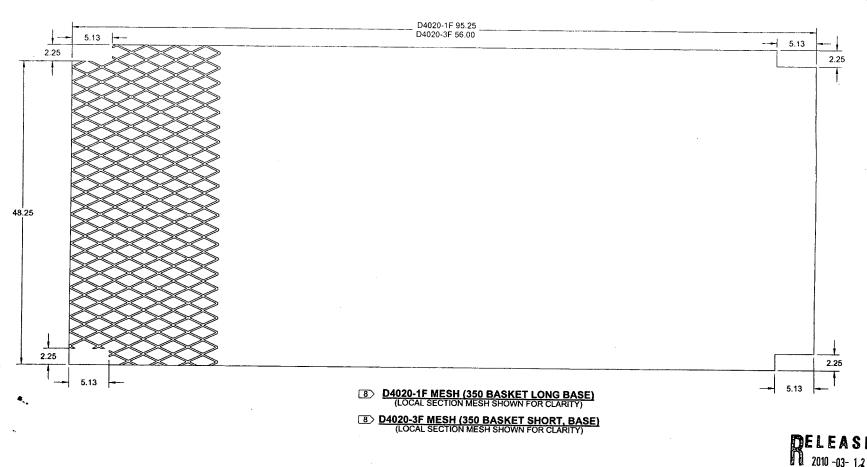
Cut Too Short

**Drill Holes** 

Drawing

Finish

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NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	9	DRAWING NO. REV. A					
MFG. APPR.	En	D4020 SHEET 4 OF 4					
APPROVED	(M)	TITLE SCALE					
DE APPR.	4	350 BASKET MESH (BASE) NTS					
DATE 10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT IS PRIVATE AND COMPRESSHIP AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS.					